

**Work Order ID 59343**

Wednesday, June 02, 2010 8:11:44 AM

*Sometimes today  
pref. this morning  
pull down*

Page 1

Item ID: D3908-1

Accept



Setup Start



Revision ID:

Item Name: Lug Plate, Aft Crosstube

Stop



Start Date: 6/2/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/2/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*MP*

Date: 10-6-

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3908

Prog Rev: *C*Dwg Rev: *C*

Deburr as required

*B10-6-3*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B10-6-3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59343**

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Item ID: D3908-1

Accept



Setup Start



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Item Name: Lug Plate, Aft Crosstube

Stop



Start Date: 6/2/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/2/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.066603

412

150

Identify as per dwg &amp; Stock Location: 94

0.00



Packaging

Memo

0.00

Packaging

10.6-4 120

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.666603

MK  
10-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, June 02, 2010 8:11:43 AM

Page 1

Work Order ID: 59343



Parent Item: D3908-1



Parent Item Name: Lug Plate, Aft Crosstube

Start Date: 6/2/2010

Required Date: 6/2/2010

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP Rev:B as  
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per PC1  
10.05.27 DD verf:EC IPP Rev:D per ECN10-581 10.05.28  
DD verf:EC

Start Qty: 12.00

Required Qty: 12.00

M304S11GA

Purchased

No

100

sf

158.8969

0.0533

0.673263



304/316 0.125 Sheet

2,  
HB10-6-3

## Location

## Loc Qty

## Loc Code

MAT

158.8969

114488

30.8969

114799

128

114488

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 59343
Description: Lug PLATE AFT CRASSTUBE		Part Number: D3908-1
Inspection Dwg: D3908-1 Rev: C		Page 1 of 1

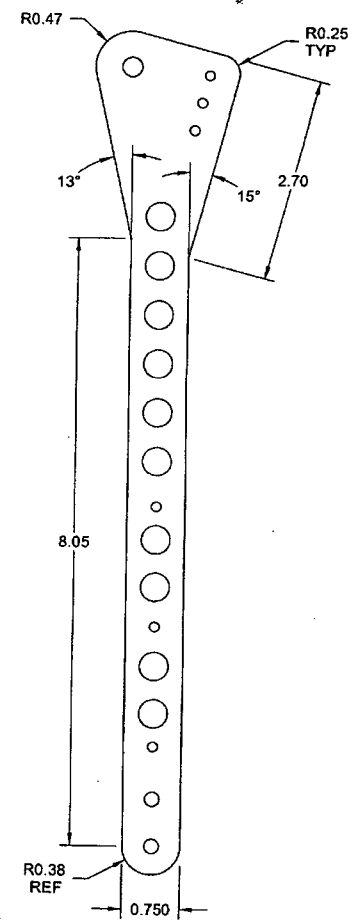
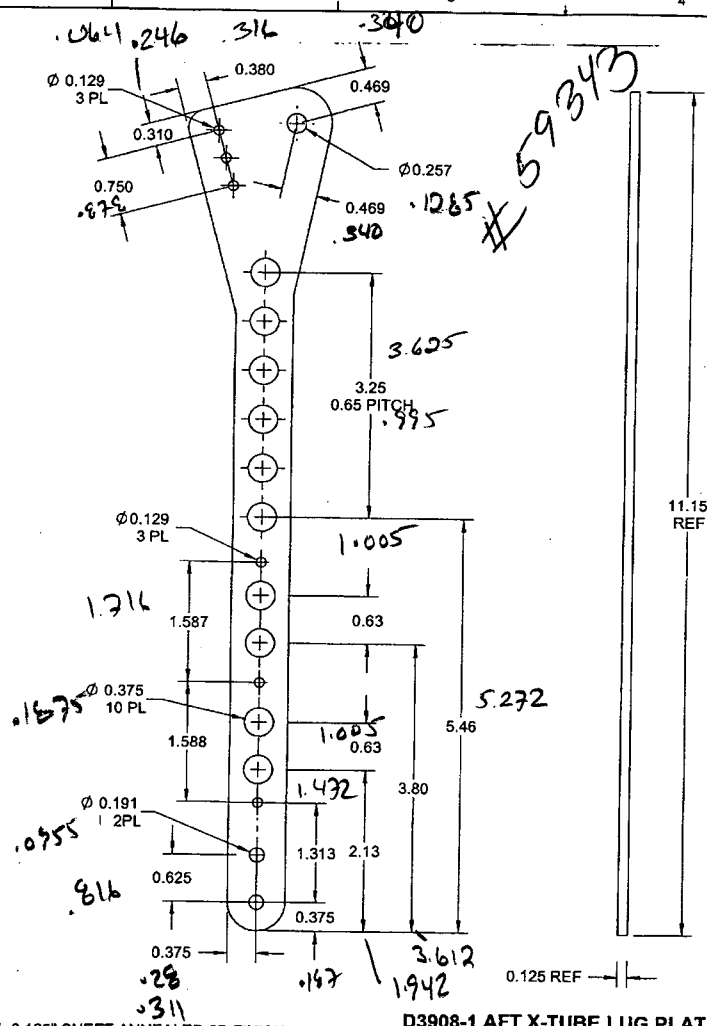
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	✓			
Ø .191	+ .005 - .001	.192	✓			
Ø .257	+ .006 - .001	.259	✓			
Ø .375	+ .006 - .001	.375	✓			
.310	± .010	.312	✓			
.380	± .010	.383	✓			
.750	± .010	.750	✓			
.464	± .010	.469	✓			
3.25	± .030	3.255	✓			
.65	± .030	.651	✓			
.63	± .030	.627	✓			
1.587	± .010	1.587	✓			
1.588	± .010	1.588	✓			
5.46	± .030	5.458	✓			
3.80	± .030	3.802	✓			
2.13	± .030	2.129	✓			
1.313	± .010	1.312	✓			
.375	± .010	.374	✓			
.625	± .010	.627	✓			
11.15	± .030	11.144	✓			
.375	± .010	.374	✓			
.750	± .010	.756	✓			
.125	± .010	.117	✗			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-6-3	Date: 10/6/03	Date:	N/A






Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**RELEASED**  
2010-05-28  
AMP

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.31 lbs

**D3908-1 AFT X-TUBE LUG PLATE**

DESIGN	JFH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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